



Rival™ RV450™ Epoxy Primer



GENERAL

DESCRIPTION

A 3.5 lb/gal (420 g/l) VOC compliant, high solids, non-sanding, epoxy primer-sealer formulated for maximum adhesion and corrosion resistance to properly treated substrates.

SUGGESTED USES

For use over properly treated substrates such as aluminum, steel and fiberglass. Treat bare steel with 5717S™ or 5718S™ conditioners. Treat aluminum with 225S™ or 226S™ conditioners.

COMPATIBLE COATINGS

Compatible with Axalta commercial transportation topcoat products.

NOT RECOMMENDED FOR

Immersion service and marginally treated metal substrates.

DRY FILM CHARACTERISTICS

| | |
|--|-----------|
| Chemical resistance | VERY GOOD |
| Humidity resistance over treated substrate | VERY GOOD |
| Weatherability with appropriate topcoat | VERY GOOD |
| Adhesion | VERY GOOD |
| Alkali resistance | VERY GOOD |
| Solvent resistance | VERY GOOD |

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

MIX RATIO

Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

COMPONENTS

| | Volume |
|------------------|--------|
| RV450 Primer | 4 |
| RV455™ Activator | 1 |

INITIAL APPLICATION VISCOSITY

14-16 seconds with #3 Zahn Cup.

INDUCTION TIME

No induction is required.

POT LIFE - 70°F (21°C)

4 hours



APPLICATION

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

APPLICATION EQUIPMENT

Refer to spray equipment documentation for setting recommendations.

Pressure Pot (recommended)
Gravity Feed
Siphon Gun
Airless Spray
Air Assisted Airless

APPLICATION

- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- Spray one full wet coat. For maximum corrosion resistance, two medium wet coats may be applied in a cross-coat application, achieving recommended 2-3 mils dry film thickness.
- No flash is necessary between cross coats.
- For increased build, apply a single pass with 10 minutes flash. This is followed by the cross-coat application as above (3-4 mils DFT).
- Topcoat can be applied wet on wet over RV450 after a 1 hour flash time.

APPLICATION SOLVENTS

No reduction necessary; product is ready-to-spray. Further reduction may result in an increased VOC.

CLEANUP SOLVENTS

3850S™ Equipment Cleaner
32030S™ Acetone

ADDITIONAL COMMENTS

Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.



DRY TIMES

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

To topcoat: 60-90 minutes
To sand: Overnight

FORCE DRY

30 minutes at 140-160°F (60-71°C)

Note: Product must be sanded if force dried or allowed to dry for more than 72 hours.



PHYSICAL PROPERTIES

| | |
|------------------------------------|--|
| Maximum Service Temperature: | 200°F (92°C) in continuous service 300°F (148°C) in intermittent heat |
| Weight Per Gallon (component only) | 12.02 lbs. |
| Weight Per Liter (component only) | 1440 grams |
| Suggested Dry Film Thickness | 2.0-3.0 mils |
| Gloss | satın |
| Color | gray |
| Flash Point (Closed Cup) | see MSDS/SDS |
| Shelf Life | 12 months minimum |

RTS mixed 4:1 with:

| | RV455 |
|--|--|
| Gallon Weight pounds per gallon | 11.14 |
| Gallon Weight grams per liter | 1335 |
| VOC AP pounds per gallon | 2.7 |
| VOC AP grams per liter | 327 |
| VOC LE pounds. per gallon | 3.1 |
| VOC LE grams per liter | 375 |
| Weight Solids | 68.0% |
| Volume Solids | 48.0% |
| Weight Volatiles | 32.0% |
| Weight Water | 0.0% |
| Volume Water | 0.0% |
| Weight Exempt Solvents | 8.0% |
| Volume Exempt Solvents | 13.0% |
| Theoretical Coverage per RTS Gallon at 1 mil DFT | 776 ft ² (72.1 m ²) |

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
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In Canada:
1.800.668.6945
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